

Work Order ID 136338

September 02, 2015 1:51:25 PM

136338

*Ship Qty 1 Asap.
Stock Balance*

Page 1

Item ID: D3574-6

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cabin Floor Protector

Start Date: 9/2/2015 Start Qty: 1.00

**** 3 SH**

Cust Item ID:

Required Date: 9/4/2015 Req'd Qty: 1.00

**** 3**

Customer:

Reference:

Approvals: Process Plan: *SH* **30150902**

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3574

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.01

FLOW CNC Waterjet

1-Cut as per Dwg D3574

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr

(3)

09/15/09

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(3)

09/15/09

[illegible]

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Item ID: D3574-6

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cabin Floor Protector

Start Date: 9/2/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/4/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location	0.00							
150									
Packaging	Memo	0.00				3	DAS 6 9-89		
Packaging									
									SEP 10 2015
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									
									MLJ SEP 10 2015

20150910
SA

Picklist Print

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Work Order ID: 136338

136338

Parent Item: D3574-6

D3574-6

Parent Item Name: Cabin Floor Protector

Start Date: 9/2/2015

Required Date: 9/4/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev :A New Issue 07.07.23 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.125-F60029-04

Purchased

No

sf

791.2344

25.35294 X 3

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

09/15/09/09

Location

Loc Qty

Loc Code

MAT

445.2

m131705

445.2

MAT019

346.0344

m129759

53.3334

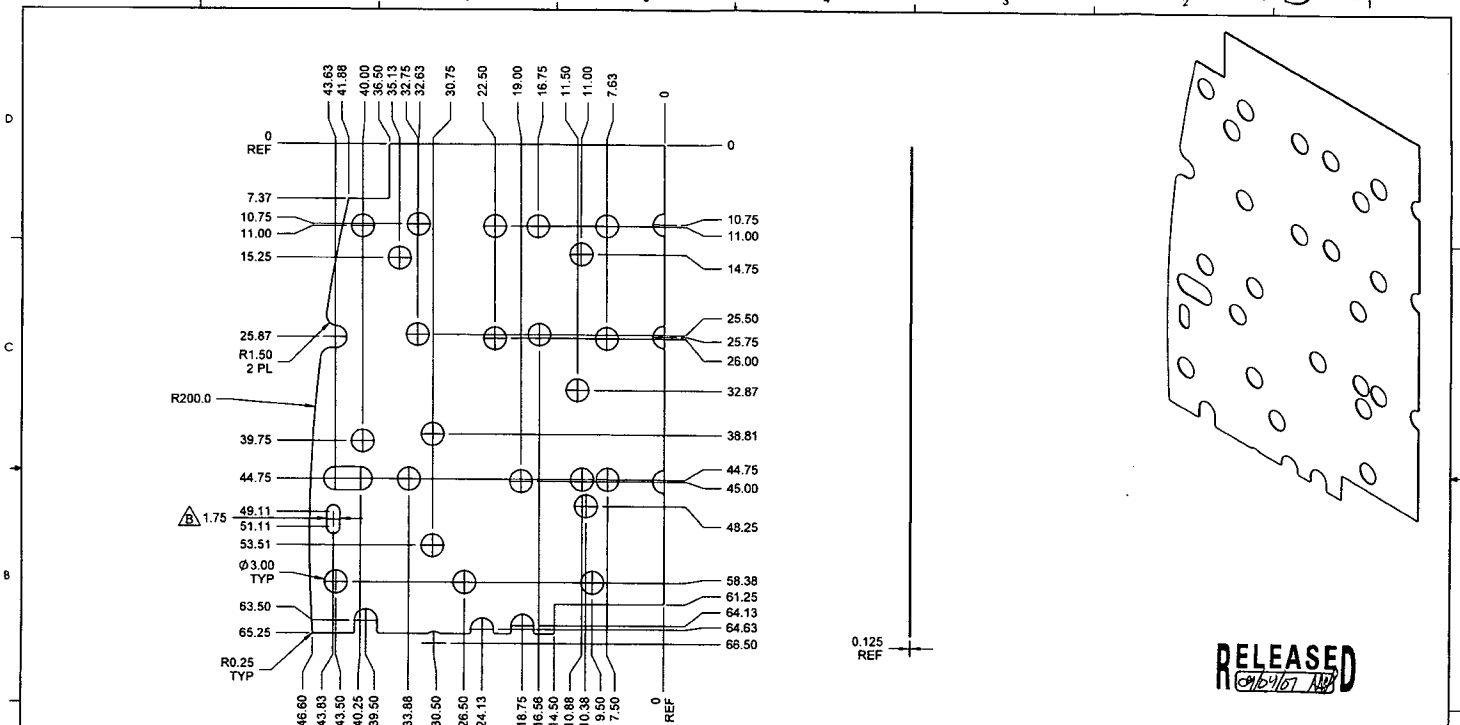
m130209

292.701

133111

75

SH 20150902
136338



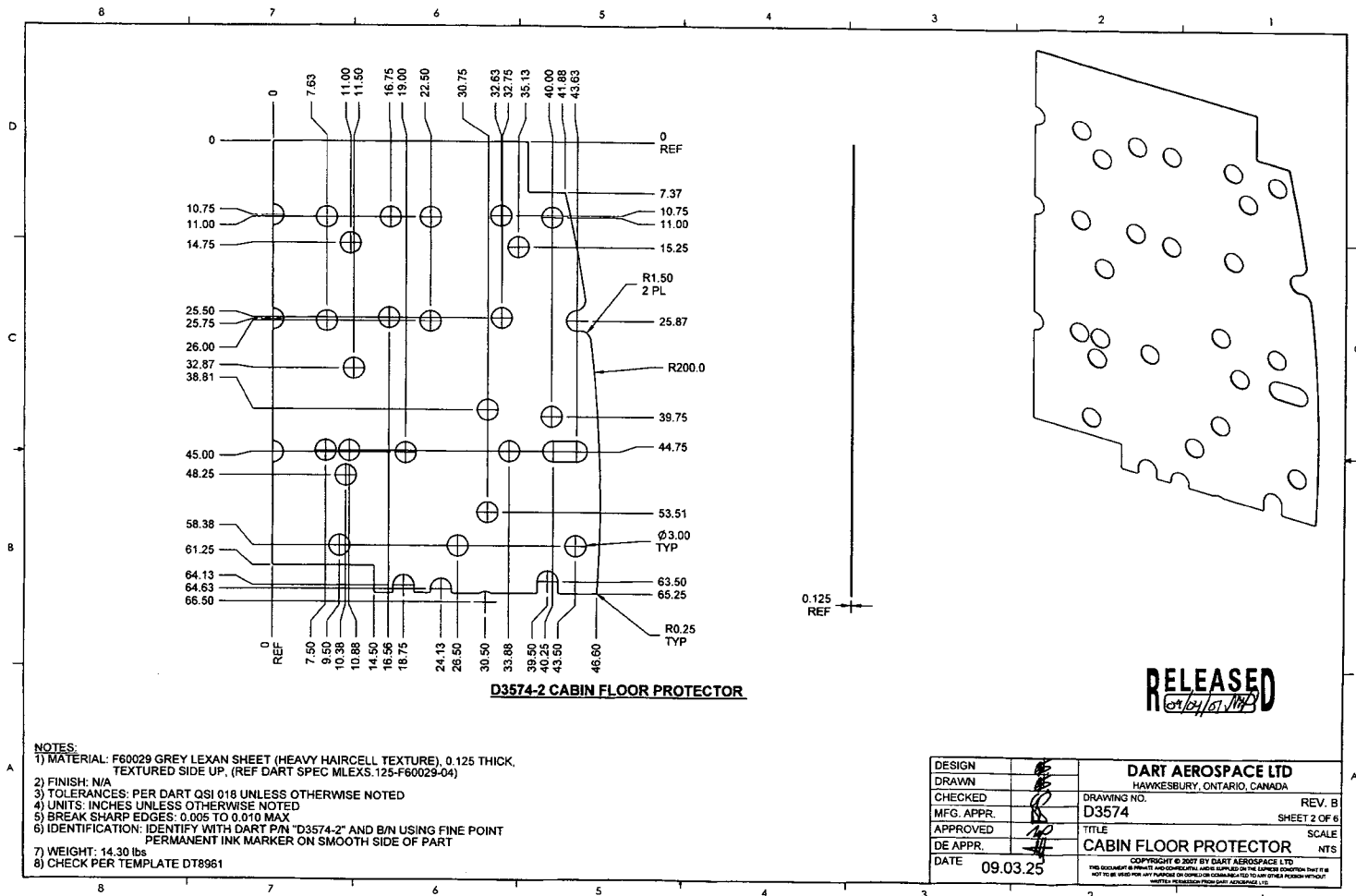
D3574-1 CABIN FLOOR PROTECTOR

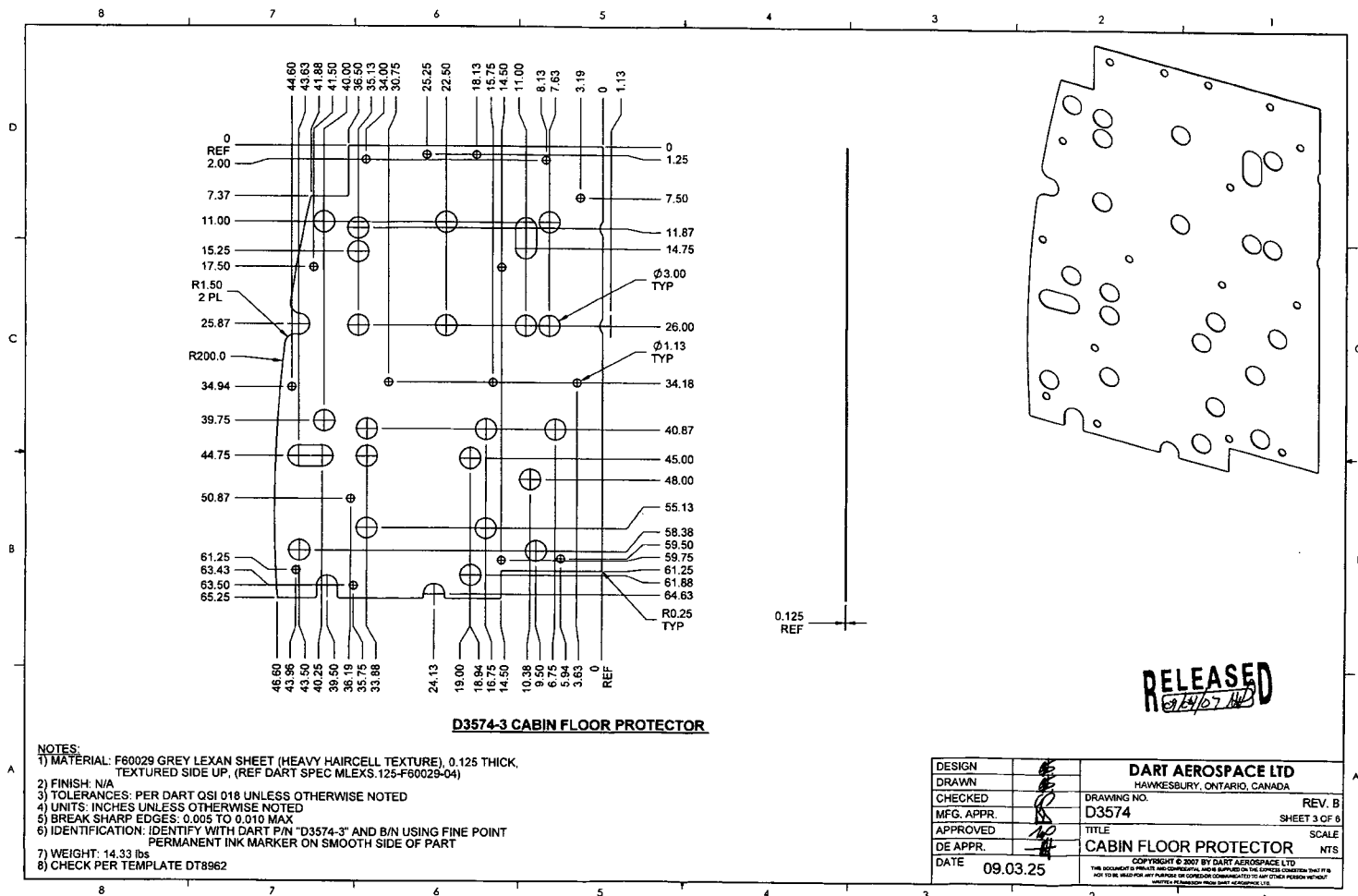
- NOTES:
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
 - 7) WEIGHT: 14.30 lbs
 - 8) CHECK PER TEMPLATE DT8961

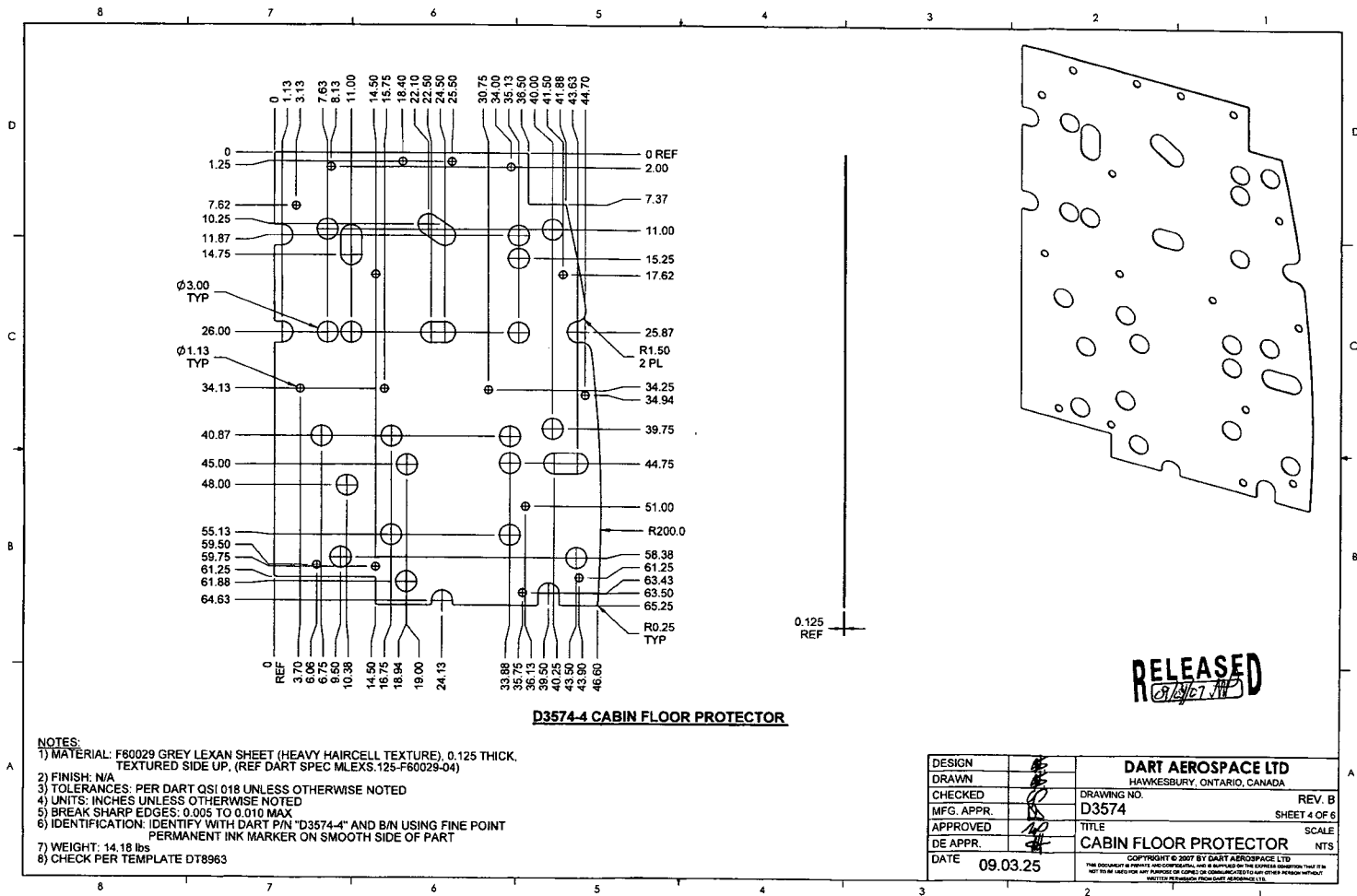
RELEASED
09/03/07

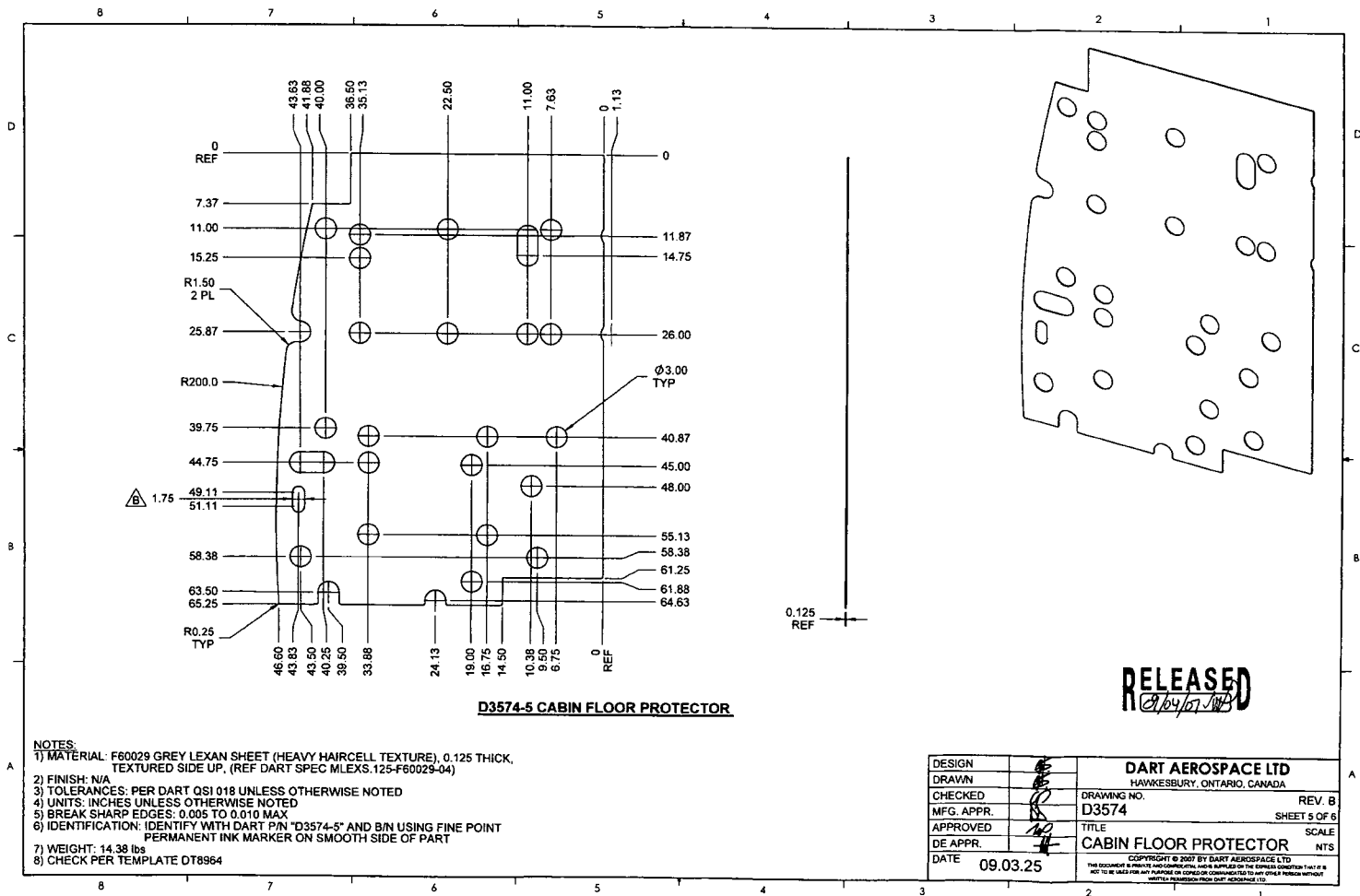
B	ADD CUT-OUT TO -1/4" FOR WEIGHT AND BALANCE DATA PLATE ZN 87-1, BB-5; -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	07.06.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D3574**
TITLE **CABIN FLOOR PROTECTOR**
REV. B
SHEET 1 OF 6
SCALE
NTS









DART AEROSPACE LTD		Work Order: 136 338
Description: Cabin Floor Protector		Part Number: D3574-6
Inspection Dwg: D3574 Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	Ø 3.00	/		Videx-2	
7.37	+/-0.030	7.37	/		Tap	
11.00	+/-0.030	11.00	/			
15.25	+/-0.030	15.25	/			
25.87	+/-0.030	25.87	/			
39.75	+/-0.030	39.75	/			
44.75	+/-0.030	44.75	/			
58.38	+/-0.030	58.38	/			
63.50	+/-0.030	63.50	/			
65.25	+/-0.030	65.25	/			
10.25	+/-0.030	10.25	/			
11.87	+/-0.030	11.87	/			
14.75	+/-0.030	14.75	/			
26.00	+/-0.030	26.00	/			
40.87	+/-0.030	40.87	/			
45.00	+/-0.030	45.00	/			
48.00	+/-0.030	48.00	/			
55.13	+/-0.030	55.13	/			
61.25	+/-0.030	61.25	/			
61.88	+/-0.030	61.88	/			
64.63	+/-0.030	64.63	/			
1.13	+/-0.030	1.13	/			
7.63	+/-0.030	7.63	/			
11.00	+/-0.030	11.00	/			
22.10	+/-0.030	22.10	/			
22.50	+/-0.030	22.50	/			
24.50	+/-0.030	24.50	/			
35.13	+/-0.030	35.13	/			
36.50	+/-0.030	36.50	/			
40.00	+/-0.030	40.00	/			
41.88	+/-0.030	41.88	/			
43.63	+/-0.030	43.63	/			
6.75	+/-0.030	6.75	/			
9.50	+/-0.030	9.50	/			

DART AEROSPACE LTD		Work Order:	136338
Description: Cabin Floor Protector		Part Number:	D3574-6
Inspection Dwg: D3574 Rev: B		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.38	+/-0.030	10.38	/			
14.50	+/-0.030	14.50	/			
16.75	+/-0.030	16.75	/			
18.94	+/-0.030	18.94	/			
19.00	+/-0.030	19.00	✓			
24.13	+/-0.030	24.13	✓			
33.88	+/-0.030	33.88	/			
39.50	+/-0.030	39.50	/			
40.25	+/-0.030	40.25	/			
43.50	+/-0.030	43.50	/			
46.60	+/-0.030	46.60	/			
0.125	+/-0.010	0.129	/			

Measured by:	<i>Dr</i>	Audited by:	DAS 38	Prototype Approval:	N/A
Date:	15/09/09	Date:	SEP 10 2015	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	
B	09.05.15	Dimensions updated per Dwg Rev B	KJ	